

Work Order ID 83834***83834***

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Thursday, April 26, 2012 1:08:23 PM

Item ID: D4463-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Upper Cut Out

Start Date: 4/26/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MF Date: 12-04-26 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(2)			
D4463	C								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg

6061. 063

Prog rev: C
Dwg rev: C

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/7/12/30

(42)

B12-4-27B12-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83834

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/26/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

130

Bend as per dwg

0.00

130

Memo

0.00

Brake NC

Brake NC

140

QC6- Inspect dimensions to drawing

0.00

140

Memo

0.00

QC

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Memo

0.00

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
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83834

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: WA 0.00

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/37

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 26, 2012 1:08:23 PM

Page 1

Work Order ID: 83834

Parent Item: D4463-5

Parent Item Name: Tank Upper Cut Out

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	286.8422	0.174	0.7326316	2.		

B12-2-07

Location

Loc Qty

Loc Code

MAT021

286.8422000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

20.94

120218

21

120866

127.142632

170.846

(12)

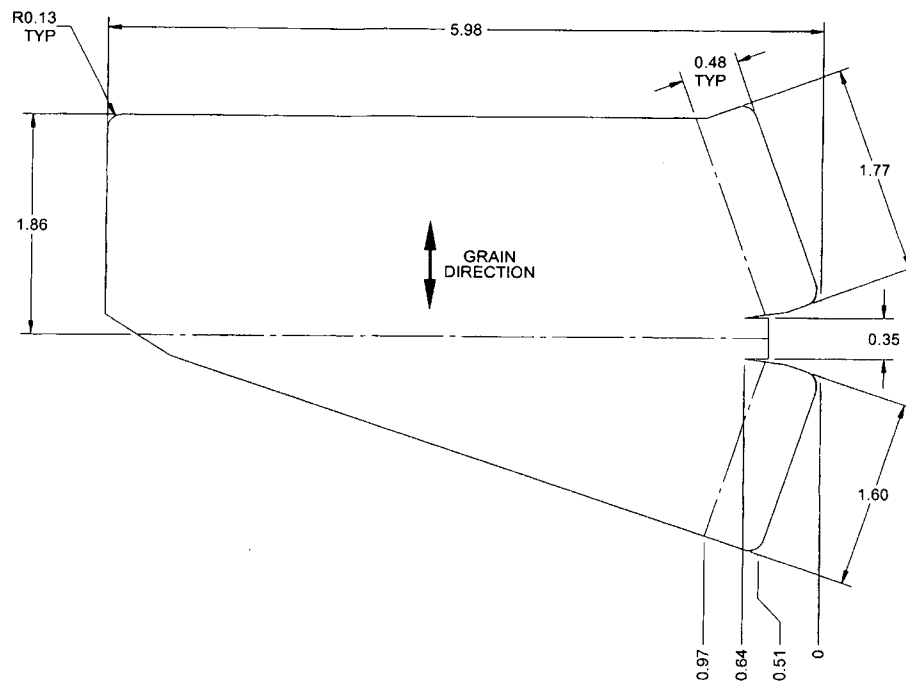
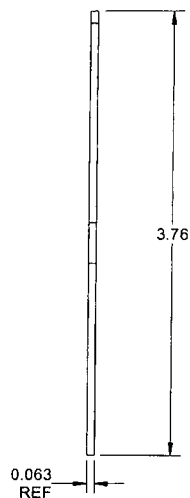
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D4463-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) PROFILE PER DWG FILE "D4463-5F-REV C.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4463	SHEET 6 OF 14
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	TANK	NTS
DATE	12.03.23	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2012-04-24

83834

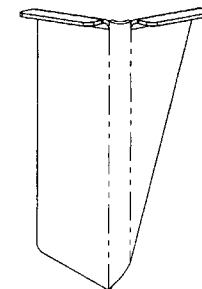
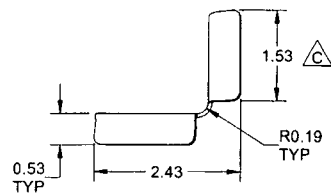
Dart Aerospace Ltd

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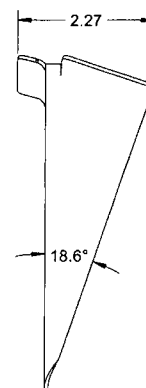
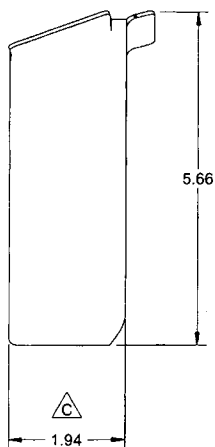
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83834



D4463-5 TANK UPPER CUT OUT

RELEASED
2012-04-24
MP

NOTES:

- 1) MATERIAL: MADE FROM D4463-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D4463	SHEET 5 OF 14
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	TANK	NTS
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